

Work Order ID 76056

76056

Page 1.

November 4, 2011 7:06:39 AM

Item ID: D2153 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Prop
 Start Date: 11/04/11 Start Qty: 36.00 ***36*** Cust Item ID:
 Required Date: 11/11/11 Req'd Qty: 36.00 ***36*** Customer:
 Reference:

Approvals: Process Plan: CL Date: 11/11/09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2153	Rev A1								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 15369 Gas Spring P/N: SL13-10 (10lb) Possible
 supplier: Spring Lift Corporation**Note: Do not ship by air****Allow an
 extra 7 to 10 business days for shipping**Material release note is required

CL 11/11/09 36

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

PC 11/11/08 (36)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control Inspect Test Spring is 10lb

count
(x36)

tested 11-15 lbs.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab Memo 1- Assemble as per Dwg D21532- Remove Spring Lift name and address with Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"	0.00 0.00							<i>ES 11/11/09</i> (36)
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Suluio</i>					<i>count</i> (36)
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <u>222</u> Memo	0.00 0.00							<i>11/11/11</i> (36)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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November 4, 2011 7:06:39 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 11/04/11 **Start Qty:** 36.00

36

Required Date: 11/11/11 **Req'd Qty:** 36.00

36

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation	Description
1	Start
2	Read input
3	Process input
4	Output result
5	End

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept
Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

P 11-11-14
(36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76056

Parent Item: D2153

Parent Item Name: Door Prop

Start Date: 11/04/11

Required Date: 11/11/11

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516	NAS1149D0563J	Purchased	No			130	Each	0.0000	2	72			
Washer						M118206		(72x)					
D2153P		Purchased	No			130	Each	0.0000	1	36			
Door Prop													
D3015-3		Manufactured	No			130	Each	645.0000	2	72			
Locknut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST030		645							
				66114		100							
				67536		45							
				74905		500							
SL69-BS		Purchased	No			100	Each	54.0000	2	72			
Ball Stud													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		54							
				118145		54							

M119563

(72x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

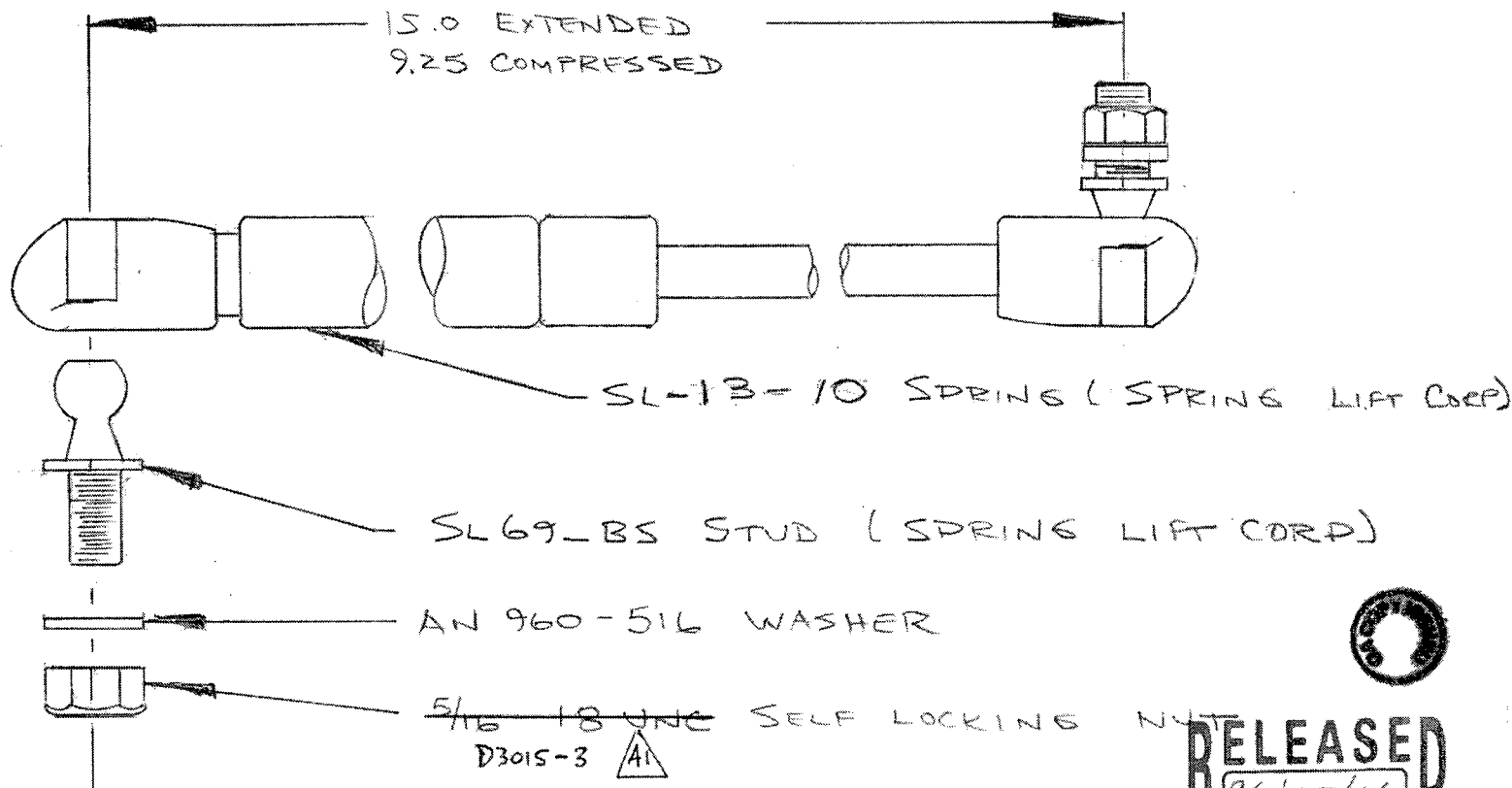
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CL 11/11/04
W/O: 76056



RELEASED
96/07/16

01.05.01 CHANGE TO D3015-3 SL 13-10 WAS SL 13-15		REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE D-DIMPLE D10740 OF SHEETS C-COUNTERSINK LENGTH DASH NO W-SPOINWELD BASIC CODES B-M520470AD B-M520470AD	PART NO. CONTRACT NO. DRAWN HATTON DATE 07.28.92 DESIGN HATTON STRESS CHECKED CLINT	DESCRIPTION DART DART AERO ACCESSORIES INC. VANCOUVER CANADA TITLE GAS SPRING ASSEMBLY CODE DZ153 SCALE 1:1 SHT 1 OF 1 REV A	MATERIAL SPEC./VENDOR	
		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 MAX 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5-3342 5. HOLES PER AND 10387	LIMITS 1. TOLERANCES — .004 & .030 2. ANGLES 3. PARALLELISM 4. ECCENTRICITY 5. SYMMETRY ABOUT ALL B/C CENTRE LINES .005	REPORT ALL DISCREPANCIES — DO NOT SCALE				

DZ153



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15369

Purchase Order Date 11/04/11

PO Print Date 11/04/11

Page Number 1 of 1

Order From :

VU-ATT001

ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

Contact Name

Vendor Phone

616-897-2285

Vendor Fax

616-897-2337

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2153P	Door Prop	11/10/11 Yes	36.00 Each	FedEx PI collect	\$4.0800	\$146.88
Special Inst:			AS PER DWG D2153 REV. A B76056 P/N: SL-13-10 (10LB)				
2	SL69-BS	Ball Stud	11/10/11 Yes	100.00 Each	FedEx PI collect	\$0.8600	\$86.00

PO Total:

\$232.88



Change Nbr: 2

Change Date: 11/04/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



TELEPHONE: 616-897-2290

MotorGuide
NEVER STOP.

CUST: 68580 MST: 52645-00

COLLECT 151793240

PRO NO: 04603
SHIP VIA: FEDEX PRIORITY OVER
BDL: 00226970002743563

FREIGHT: _____

F ATTWOOD / MOTORGUIDE
R
D 1016 NORTH MONROE
M LOWELL MI 49331-0260

DART AERO LTD.
T 1270 ABERDEEN STREET
D

HAWKESBURY ON K6A 1K7

CRTS: 1 PO#: PO15369

WGT: 15 DATE: 11/04/11

SPUR: 9

LABEL NO:
5693380001

---ROUTING GUIDE INFO---

---SHIPPED---

CRTS	QTY	LOCATN	UM	PART# / UPC	DESCRIPTION / SKU	LN	QTY	WGT
1	100	W03131	EA	SL69-B5-1	10MM BALL STUD W/THRD	2	100	3
1	36	W03711	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	1	36	12

Sululog

